

Work Order ID 138776

November 12, 2015 1:32:32 PM

138776

Page 1

Item ID: D212-725-1-061F

Accept

N1900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 11/12/2015 Start Qty: 1.00

Required Date: 12/23/2015 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: SW

Date: 11/11/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<u>Draw Nbr</u>	<u>Revision Nbr</u>								
D212-725-1	E <u>A</u>								
100 <u>D4221</u>	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>	2- Deburr if necessary							
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

Ship Dec 23/

(5) 02/15/12/15

(5) 02/15/12/15

(5) DEC 15 2015 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Work Order ID 138776

November 12, 2015 1:32:32 PM

138776

Page 2

Item ID: D212-725-1-061F

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 11/12/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00

1

Customer:

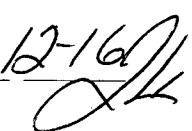
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
121	Chemical Conversion Coat per QSI005 4.1	0.00				5	0	15-12-16	
121									
HandFinish	Memo	0.00							
Hand Finishing									
122	QC3- Inspect Part Finish	0.00							
122									
QC	Memo	0.00				5	15-12-17	PD	
Quality Control									
130	Identify as per dwg & Stock Location: <u>51573</u>	0.00							
130									
Packaging	Memo	0.00				5			
Packaging	***FLAT PATERN ONLY***								

DEC 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
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Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Work Order ID 138776***138776***

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November 12, 2015 1:32:32 PM

Item ID: D212-725-1-061F

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N900040100Setup Start ***NS1***

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Item Name: Bracket

Stop ***NS2***

Start Date: 11/12/2015 Start Qty: 1.00

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Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS

DEC 18 2015

MCS

DEC 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

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Page 1

Work Order ID: 138776

138776

Parent Item: D212-725-1-061F

D212-725-1-061F

Parent Item Name: Bracket

Start Date: 11/12/2015

Required Date: 12/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-05-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased			No	100	sf	100.9000	0.26	0.273684			
									**			02/15/12/15	
M2024T3S 040													
2024-T3 .040 sheet													

Location

Loc Qty

Loc Code

MAT022

100.9

m132359
m133548

52.9

48

2

DART AEROSPACE LTD		Work Order:	138776
Description: Bracket <i>A4221</i>		Part Number:	D212-725-1-061F
Inspection Dwg: D212-725-1 Pg 25 of 82 <i>Rev E</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.080	+0.004/-0.001	Ø.081	/		Vide-02	
Ø0.098	+0.004/-0.001	Ø.100	/		Tap	
Ø0.129	+0.004/-0.001	Ø.131	/			
10.727	+/-0.010	10.735	/			
0.550	+/-0.010	.555	/			
1.100	+/-0.010	1.102	/			
0.600	+/-0.010	.603	/			
0.250	+/-0.010	.253	/			
0.162	+/-0.010	.165	/			
1.250	+/-0.010	1.253	/			
2.394	+/-0.010	2.396	/			
2.724	+/-0.010	2.726	/			
0.903	+/-0.010	.905	/			
1.183	+/-0.010	1.185	/			
1.975	+/-0.010	1.977	/			
4.376	+/-0.010	4.379	/			
3.157	+/-0.010	3.159	/			
3.348	+/-0.010	3.349	/			
0.040	+/-0.010	.040	/			

Measured by:	<i>DE</i>	Audited by:	<i>DAS</i>	Preliminary Approval:	
Date:	15/12/15	Date:	DEC 15 2015	Date:	

Rev	Date	Change	Revised by	Approved
A	10.11.15	New Issue	KJ	<i>[Signature]</i>

